



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5371-2

Job Sheet 181908



Part No: D5371-2

Job Qty: 8 ea

Part Name: Hook



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV.A NEW ISSUE JFS 15/12/14 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	8 Ea		9/28/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	8 pcs		9/28/18	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	8 pcs		9/28/18	0.00	8.01	HAAS 5 Axis		
120	QC	8 pcs		9/28/18	0.00	0.00	QC2 Machining-4		
130	QC	8 pcs		9/28/18	0.00	0.00	QC8 Machining-4		
140	HandFinish	8 pcs		9/28/18	0.00	0.80	HandFinish1		
150	Powdercoat	8 pcs		9/28/18	0.00	0.24	Powdercoat11		
155	QC	8 pcs		9/28/18	0.00	0.00	QC3		
180	Packaging	8 pcs		9/28/18	0.00	0.00	Packaging3-2		
190	QC21-SA	8 Ea		9/28/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 3.250"

Descriptions: 110 - 1-Machine as per folio FB446

150 - START TIME:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	2.1680 ft (.271 ea)	90-Start up Operation	5112 684

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	2	50	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework _____ Scrap _____ Use-as-is _____ Suspected Unapproved _____	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 50%;"> Water Jet _____ Rig. Coord. _____ Packaging _____ Supplier _____ </td> <td style="width: 50%;"> Engineering _____ Quality _____ Other _____ </td> </tr> </table>	Water Jet _____ Rig. Coord. _____ Packaging _____ Supplier _____	Engineering _____ Quality _____ Other _____																																																																								
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Date: 09/22/18
 Instructions: Various STCs
 Exp Date:
 Inspector:
 Revision:
 Serial No/Batch: S112685
 Job No: 181908
 Part: D5371-2
 Container No: S112685

 DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

eg. ☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
 ulled ☐ Part Lost/Missing
 ce ☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

DART AEROSPACE LTD		Work Order:	181908
Description: Hook		Part Number:	D5371-2
Inspection Dwg: D5371 Rev: A		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.45	+/-0.030	5.449	✓		SLIO	Vern
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.28	+/-0.030	.280	✓		"	
30°	+/-0.5°	30°	✓		Protractor	
R0.39	+/-0.030	.390	✓		Rad gauge	
10°	+/-0.5°	10°	✓		Protractor	
R0.28	+/-0.030	.280	✓		Rad gauge	
34°	+/-0.5°	34°	✓		Protractor	
R0.39	+/-0.030	.390	✓		Rad gauge	
0.86	+/-0.030	.865	✓		SLIO	Vern
0.200	+/-0.010	.202	✓		"	
2.28	+/-0.030	2.280	✓		"	
R0.16	+/-0.030	.160	✓		Rad gauge	
70°	+/-0.5°	70°	✓		Protractor	
0.40	+/-0.030	.407	✓		SLIO	Vern
2.61	+/-0.030	2.610	✓			
0.174 x 45°	+/-0.010 x +/-0.5°	.172	✓			
Ø0.204	+0.005/-0.001	.205	✓			
0.374	+/-0.010	.373	✓			
0.748	+/-0.010	.751	✓			
0.35	+/-0.030	.350	✓			
0.750	+/-0.005	.750	✓			
3.250	+/-0.005	3.250	✓			
Ø 0.550	+/-0.010	.550	✓			
R0.13	+/-0.030	.130	✓		Rad gauge	
R0.02	+/-0.030	.015	✓		"	
1.97	+/-0.030	1.968	✓		SLIO	Vern
2.43	+/-0.030	2.429	✓			
1.87	+/-0.030	1.864	✓			
0.050	+0.005/-0.000	.054	✓			

Measured by:	20 9-89	Checked by:		QC Inspector:	
Date:	18-09-22	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					